



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |






**NOTE:** Date & initial all entries



**Work Order ID 73329**




Wednesday, August 31, 2011 11:01:55 AM



Page 2

Item ID: D4164-041      Accept            Setup      Start        
Revision ID:      Stop        
Item Name: Nut Plate Adapter Assembly  
Start Date: 9/1/2011      Start Qty: 40.00            Cust Item ID:  
Required Date: 9/15/2011      Req'd Qty: 40.00            Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start        
QC:      Date:      SPC (Y/N):      Date:      Stop      

| Sequence ID/<br>Work Center ID                                                                           | Operation<br>Description                      | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|----------------------------------------------------------------------------------------------------------|-----------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br><br>Small Fab    | Small Fab                                     | 0.00                 |         |        |              |               |               |                  |                |
| Small Fab                                                                                                | Memo                                          | 0.00                 |         |        |              |               |               |                  |                |
| Small Fab                                                                                                | 1- Deburr<br>2-C'sink as per Dwg              |                      |         |        |              |               |               |                  |                |
| 140<br><br>QC          | QC5- Inspect part completeness to step on W/O | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                                                                                          | Memo                                          | 0.00                 |         |        |              |               |               |                  |                |
| 141<br><br>HandFinish | Chemical Conversion Coat per QSI005 4.1       | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                                                                                           | Memo                                          | 0.00                 |         |        |              |               |               |                  |                |

*Handwritten notes:*  
- Next to 130: *Small Fab*  
- Next to 140: *QC5- Inspect part completeness to step on W/O*  
- Next to 141: *HandFinish*  
- Large handwritten signature/initials: *8/31/11/14* (circled)  
- Another handwritten signature/initials: *48x* (circled)  
- Another handwritten signature/initials: *48x* (circled)  
- Another handwritten signature/initials: *48x* (circled)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

\_\_\_\_\_

Page 3

**Accept**

(b) (7)(C), (b) (7)(D)

**Setup Start**

**Stop**

\_\_\_\_\_

**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start

### Process Plan:

Date:

**Tooling:**

**Date:**

**Stop**

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

## Insp. Stamp

0.00

0.00

0.00

0.00

Install Nut plate as per Dwg

0.00

0.00

## Quality Control

H8 BR 11-11-15.

ES 11/16 (48)

comp

374

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, August 31, 2011 11:01:51 AM

Page 1

Work Order ID: 73329

Parent Item: D4164-041

Parent Item Name: Nut Plate Adapter Assembly




Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 10-09-07 JLM VERIFIED BY:DD

| Component Item ID/<br>Item Name                                                                                         | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|-------------------------------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.040<br><br>6061-T6 .040 Sheet |                        | Purchased     | No          |                     |                  | 100             | sf                 | 94.8000         | 0.001       | 0.042105     |               |                |        |
|                                                                                                                         |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                                                                                                         |                        |               |             | MAT021              |                  | 94.8            |                    |                 |             |              |               |                |        |
|                                                                                                                         |                        |               |             | 113004              |                  | 8.5             |                    |                 |             |              |               |                |        |
|                                                                                                                         |                        |               |             | 117653              |                  | 86.3            |                    |                 |             |              |               |                |        |
| MS21059L3<br><br>Nut Plate             |                        | Purchased     | No          |                     |                  |                 | Each               | 264.0000        |             |              |               |                |        |
|                                                                                                                         |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                                                                                                         |                        |               |             | ST301               |                  | 258             |                    |                 |             |              |               |                |        |
|                                                                                                                         |                        |               |             | 118234              |                  | 58              |                    |                 |             |              |               |                |        |
|                                                                                                                         |                        |               |             | 118614              |                  | 200             |                    |                 |             |              |               |                |        |
|                                                                                                                         |                        |               |             | ST302               |                  | 6               |                    |                 |             |              |               |                |        |
|                                                                                                                         |                        |               |             | 116706              |                  | 6               |                    |                 |             |              |               |                |        |
| MS20426AD3-3<br><br>Rivet            |                        | Purchased     | No          |                     |                  |                 | Each               | 1,797.000       |             |              |               |                |        |
|                                                                                                                         |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                                                                                                         |                        |               |             | ST316               |                  | 1797            |                    |                 |             |              |               |                |        |
|                                                                                                                         |                        |               |             | 19099               |                  | 1797            |                    |                 |             |              |               |                |        |

1B11-11

48

113004

40  
EBS 11/11/16

48

80  
EBS 11/11/16

96

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

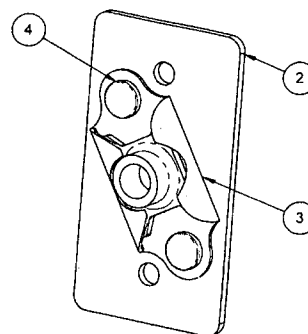
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

| ITEM | QTY<br>-041 | PART NUMBER  | DESCRIPTION                |
|------|-------------|--------------|----------------------------|
| 1    | X           | D4164-041    | NUT PLATE ADAPTER ASSEMBLY |
| 2    | 1           | D4164-1      | NUT PLATE ADAPTER          |
| 3    | 1           | MS21059L3    | NUT PLATE                  |
| 4    | 2           | MS20426AD3-3 | RIVET                      |



**D4164-041 NUT PLATE ADAPTER ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4164-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.006 lbs

|                                                                                                                                                                                                                                |                    |                                        |              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|----------------------------------------|--------------|
| A                                                                                                                                                                                                                              | NEW ISSUE          | RF                                     | 10.07.22     |
| REV.                                                                                                                                                                                                                           | DESCRIPTION        | BY                                     | DATE         |
| DESIGN                                                                                                                                                                                                                         | KB                 | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          | RF                 | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        | <i>[Signature]</i> | DRAWING NO.                            | REV. A       |
| MFG. APPR.                                                                                                                                                                                                                     | <i>[Signature]</i> | <b>D4164</b>                           | SHEET 1 OF 2 |
| APPROVED                                                                                                                                                                                                                       | <i>[Signature]</i> | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | <i>[Signature]</i> | <b>NUT PLATE ADAPTER ASSY</b>          | NTS          |
| DATE                                                                                                                                                                                                                           | 10.07.22           | COPYRIGHT © 2010 BY DART AEROSPACE LTD |              |
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**RELEASED**  
2010-09-07  
*MB*

*73329*

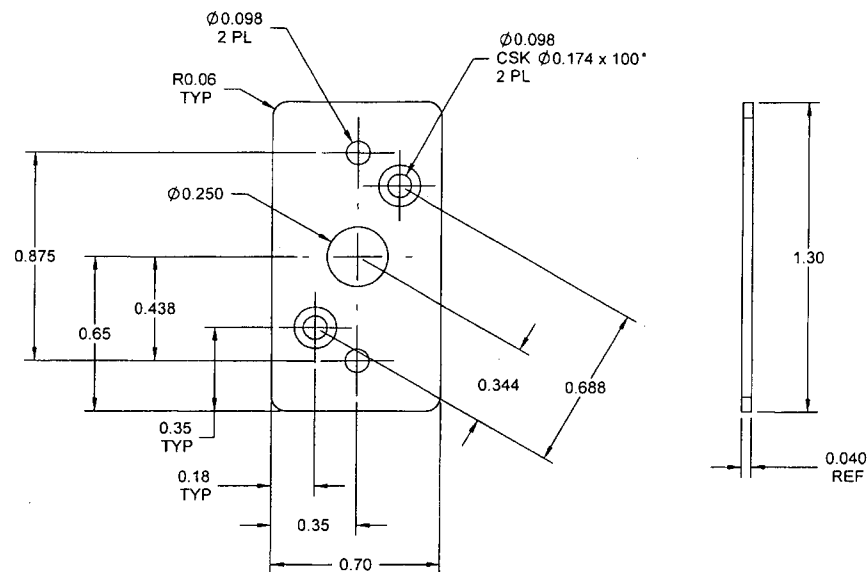
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D4164-1 NUT PLATE ADAPTER**

**NOTES:**

- 1) MATERIAL: 6061T6/T62 ALUMINUM SHEET, 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
PER DART SPEC. M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

|                                                                                                                                                                                                                               |                    |                                        |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                        | KB                 | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                         | RF                 | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                       | <i>[Signature]</i> | DRAWING NO.                            | REV. A       |
| MFG. APPR.                                                                                                                                                                                                                    | <i>[Signature]</i> | D4164                                  | SHEET 2 OF 2 |
| APPROVED                                                                                                                                                                                                                      | <i>[Signature]</i> | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                      | <i>[Signature]</i> | NUT PLATE ADAPTER ASSY                 | NTS          |
| DATE                                                                                                                                                                                                                          | 10.07.22           | COPYRIGHT © 2010 BY DART AEROSPACE LTD |              |
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2010-09-07  
*[Signature]*

73329

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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries